

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001211**Date Inspected:** 06-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item Description	WBS	Dwg No.	Status
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1 UT OBG Deck Mock-up U-ribs PJP

The QA inspector performed ultrasonic testing (UT) verifications at partial penetration joint (PJP) at the junction of the deck mock-up to U-ribs by the areas where ZPMC was going to remove the macroetch test sample selected by Caltrans.

The QA inspector found the following results:

Macroetch Test Samples #

1A1 UT no LOP recorded from Y locations 0 to 200 mm

3B3 UT no LOP recorded in between Y locations 8290 and 9100 mm

4A3 UT no LOP recorded in between Y locations 11500 and 12500 mm

4B3 UT no LOP recorded in between Y locations 9250 and 10250 mm

5A3 UT no LOP recorded in between Y location 0 and 200 mm

Weld joint # 10, U-05 no LOP was recorded in between Y location 11440 thru 12430 mm.

2 Floor beam welding

The QA inspector observed welder Yuan Wensong and Hong Shuilifu performing welding operations with the flux cored arc welding (FCAW) process, fillet weld, on the horizontal(2F) position at the junction of the floor beam web to the stiffeners joints # FB-007-02-012 and FB-007-02-011.

The QA inspector observed welder Li Hai Tao performing welding operations with the FCAW process, fillet welds, on

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the horizontal (2F) position at the junction of the floor beam web to the stiffeners joints # FB-007-02-012 and FB-007-02-011.

The QA inspector performed random verifications of the welding parameters. The QA inspector found that welding parameters appeared to be in compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
